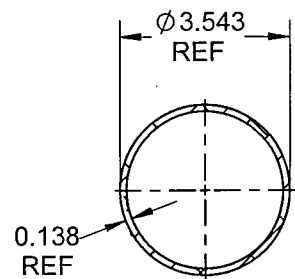
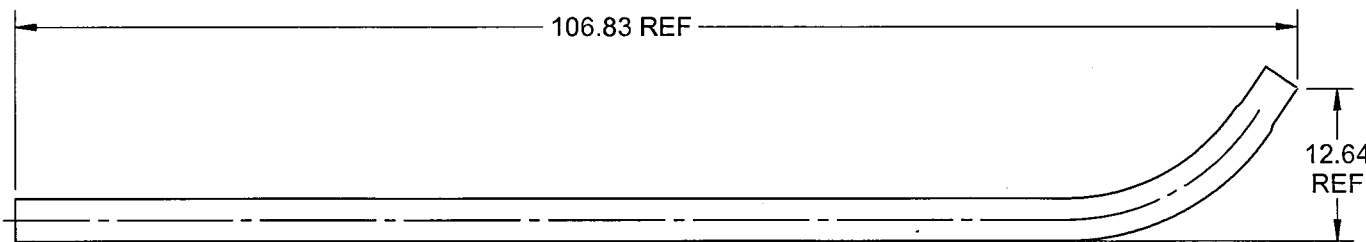


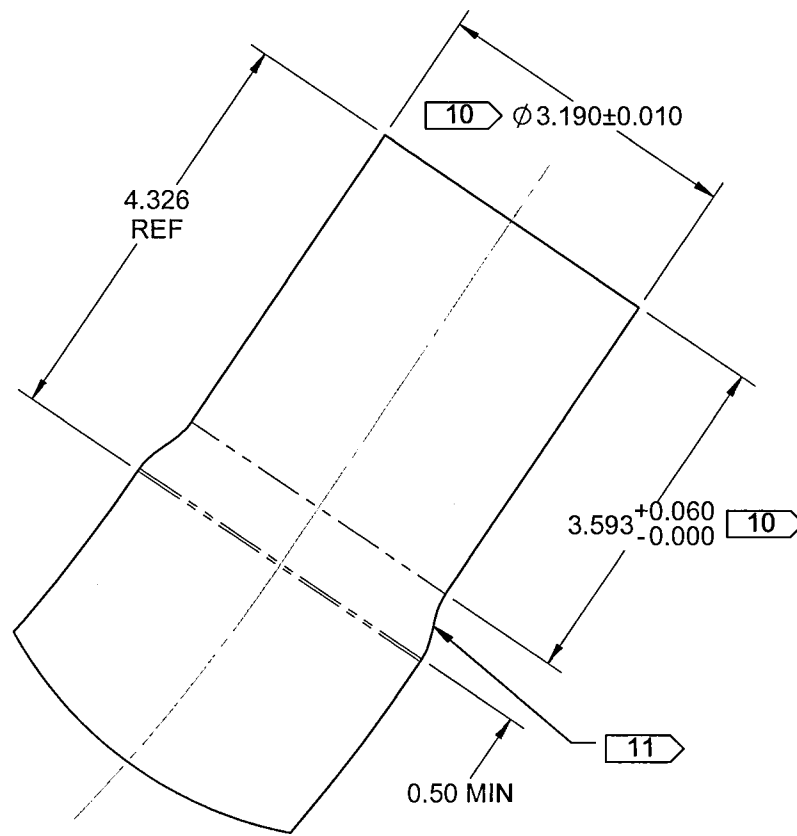
**D5611-1 SKIDTUBE (EC130)**



**SECTION A-A**  
SCALE 2X



**AUXILIARY VIEW**  
SCALE 0.5X



**DETAIL B**  
SCALE 4X

RELEASED  
2018 OCT 02  
ECN 18-817

- NOTES:**
- 1) MATERIAL: MAKE FROM D6031-120  
STRAIGHT LENGTH = 120.00" (BEFORE BENDING / TRIMMING)
  - 2) FINISH: CHEMICAL CONVERSION COAT EXTRUSION PER DART QSI 005 4.1 PRIOR TO SENDING EXTRUSION TO OUTSIDE VENDOR
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 16.40 lbs
  - 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
  - 9) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.
  - 10) SWAGE 3.593+0.060/-0.000 LENGTH AT THE BENT END OF THE TUBE TO Ø3.190±0.010
  - 11) SWAGED TRANSITION MUST BE SMOOTH, GRADUAL, AND WITHOUT VISIBLE DISCONTINUITIES

APPROVED

|            |             |  |              |
|------------|-------------|--|--------------|
| A          | NEW ISSUE   | ZF   | 18.05.07     |
| REV.       | DESCRIPTION | BY   | DATE         |
| DESIGN     | NO          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | ZF          |  |              |
| CHECKED    | MW          | DRAWING NO.  | REV. A       |
| MFG. APPR. | JFS         | <b>D5611</b>   | SHEET 1 OF 1 |
| APPROVED   | NO          | TITLE  | SCALE        |
| DE APPR.   | CP          | <b>SKIDTUBE (EC130)</b>  | NTS          |
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